



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

46"
D4149-5

Job Sheet 169891



Part No: D4149-5

Job Qty: 15 ea

Part Name: Eyebolt Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-2		<i>18/02/14</i>
100	Doosan	15 pcs	1/12/18	1/12/18	0.33	4.02	Doosan		<i>18/02/14</i>
120	QC	15 pcs	1/12/18	1/12/18	0.00	0.00	QC8		<i>15/02/14</i>
150	Packaging	15 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-2		<i>15/02/14</i>
160	QC21-SA	15 Ea	1/12/18	1/12/18	0.00	0.00	QC21	<i>ST086</i>	<i>ST086</i>
Part Op Descriptions: 100 - turn as per dwg and folio FA950									<i>DAS 21 9-00 FEB 14 2018</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R1.000	4	18	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Stud	0.250Inches + 0.003 - 0.000	<i>0.250</i> 0.253 0.250	Diameter	
2	Eyebolt Stud	1.380Inches ± 0.030	<i>1.380</i> 1.410 1.350		
3	Eyebolt Stud	0.400Inches + 0.000 - 0.010	<i>0.395</i> 0.400 0.390		
4	Eyebolt Stud	0.700Inches + 0.010 - 0.000	<i>0.707</i> 0.710 0.700		
5	Eyebolt Stud	0.030Inches ± 0.010	<i>0.030</i> 0.040 0.020	Radius	
6	Eyebolt Stud	0.375Inches + 0.000 - 0.020	<i>0.365</i> 0.375 0.355	Diameter	
7	Eyebolt Stud	0.700Inches + 0.000 - 0.010	<i>0.695</i> 0.700 0.690	Diameter	
8	Eyebolt Stud	0.200Inches ± 0.010	<i>0.200</i> 0.210 0.190		
9	Eyebolt Stud	1.500Inches ± 0.010	<i>1.501</i> 1.510 1.490		
10	Eyebolt Stud	0.060Inches ± 0.030	<i>0.060</i> 0.090	Radius	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

			0.030	
11	Eyebolt Stud	2.880Inches ± 0.030	<i>2.880</i>	2.910 2.850
12	Eyebolt Stud	0.310Inches ± 0.010	<i>0.312</i>	0.320 0.300
13	Eyebolt Stud	0.750Inches + 0.003 - 0.000	<i>0.751</i>	0.753 0.750
14	Eyebolt Stud	0.750Inches ± 0.030	<i>0.746</i>	0.780 0.720
15	Eyebolt Stud	0.735Inches ± 0.010	<i>0.740</i>	0.745 0.725

Plex 1/3/18 8:43 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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Container No: S042082



Part: D4149-5

Serial No/Batch: S042082

Revision: D4149

Inspector:

Date: 02/13/18 17:58 PM

FAULT CATEGORY

ect te/Unqualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
ete/Unclear	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence